

Date: Tuesday, 23/12/2008 1:23:02 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DOUBLER
Job Number : 44302	
Estimate Number : 12951	
P.O. Number :	Part Number : D32593
This Issue : 23/12/2008 S.O. No. :	Drawing Number : D3259 REV A1
Prsht Rev. : NC	Project Number : N/A
First Issue : 1/1 Type : SMALL /MED FAB	Drawing Revision : A1
Previous Run : 43772	Material :
Written By :	Due Date : 12/01/2009 Qty: 6 Um: Each
Checked & Approved By :	
Comment : Est Rev:A New Issue 07-07-19 JLM Verified By:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S063	2024-T3 .063 sheet
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Comment: Qty.: 1.4574 sf(s)/Unit Total : 8.7444 sf(s)
 2024-T3 .063 sheet 110337x2
 Batch: ~~110337~~ 118 9-2-12

2.0	WATER JET 109 463 Y6	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3259
 Dwg Rev: A1
 Prog Rev: A1

1189-2-12

(8)

2-Deburr if necessary 1189-2-12

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

1189-2-12

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

809/02/12 (8)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 1-C Sink Holes as per Dwg D3259

809/02/25 (8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 23/12/2008 1:23:02 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 44302

Part Number: D32593

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Form as per Dwg D3259

SB 09/02/26

PTD
7

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/02/26

77

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BR 09-02-26

7

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-02-26

7

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Store

9h/b6

SCP

7X

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/02

Job Completion








YMF
09-02-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/02/26	6	1 piece crack at the bend R.C. process	 DS/042	Scrap + destroy No replace Grain direction IS as per dwg. requirements	 09/02/26	 09/02/26	 DS/042	 DS/02-26

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 4430 2
Description: Doubler		Part Number: D3259-3/-4
Inspection Dwg: D3259	Rev: A1	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
10.062	+/-0.010	10.063	u			
9.000	+/-0.005	8.997	✓			
1.000	+/-0.005	.998	✓			
0.260	+/-0.010	.259	✓			
0.900	+/-0.010	.904	✓			
R0.25	+/-0.030	.25	✓			
R0.50	+/-0.030	.50	✓			
5.000	+/-0.005	4.999	✓			
0.875	+/-0.005	.874	✓			
1.300	+/-0.010	1.307	✓			
12.000	+/-0.005	12.000	✓			
3.500	+/-0.005	3.498	✓			
0.875	+/-0.005	.873	✓			
R0.13	+/-0.030	.13	✓			
0.500	+/-0.005	.502	✓			
0.525	+/-0.005	.524	✓			
1.80	+/-0.030	1.805	✓			
Ø0.128	+0.005/-0.000	.130	✓			
Ø0.377	+0.005/-0.000	.379	✓			
Ø0.098	+0.005/-0.000	.099	✓			
0.063 thick	+/-0.005	.062	✓			
Grain Direction	N/A		✓			

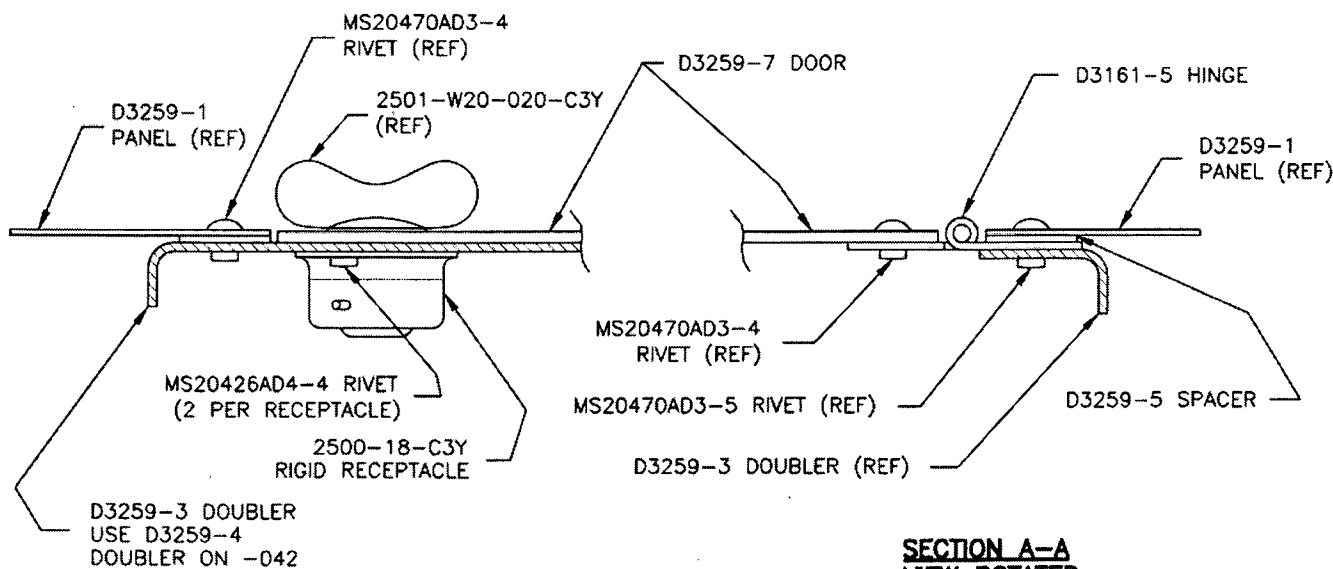
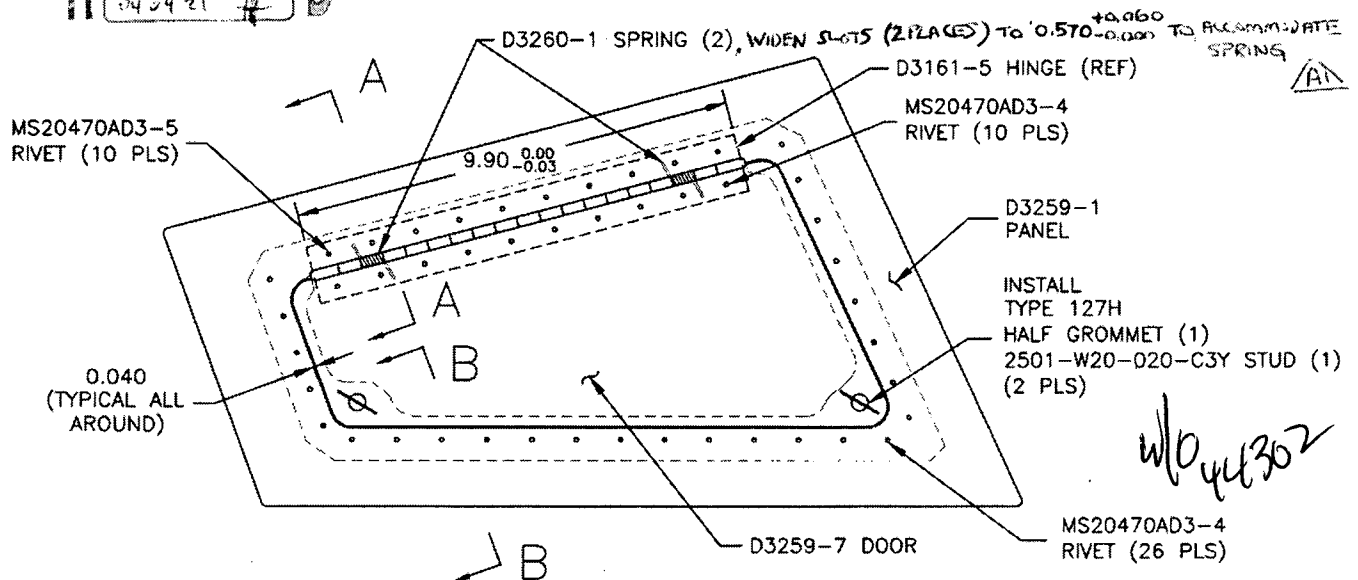
Measured by: JB	Audited by: S	Prototype Approval:	N/A
Date: 9-2-12	Date: 09/02/12	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.08.25	New Issue	P/O D412-705-019 KJ/JLM	



DESIGN	RF	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	JP	APPROVED	JP	DRAWING NO. D3259 REV. A SHEET 1 OF 6
DATE	04.02.25	TITLE	ACCESS PANEL ASSEMBLY	SCALE 1:4
A	04.02.25	NEW ISSUE		
A1	CP JP 04.08.11	WIDEN SLOTS TO ALLOW OPERATION OF SPRINGS		

RELEASED
040421



SECTION A-A
VIEW ROTATED

SECTION B-B
VIEW ROTATED

D3259-041 ACCESS PANEL ASSEMBLY (SHOWN)
D3259-042 ACCESS PANEL ASSEMBLY (OPPOSITE)

- 1) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 2) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

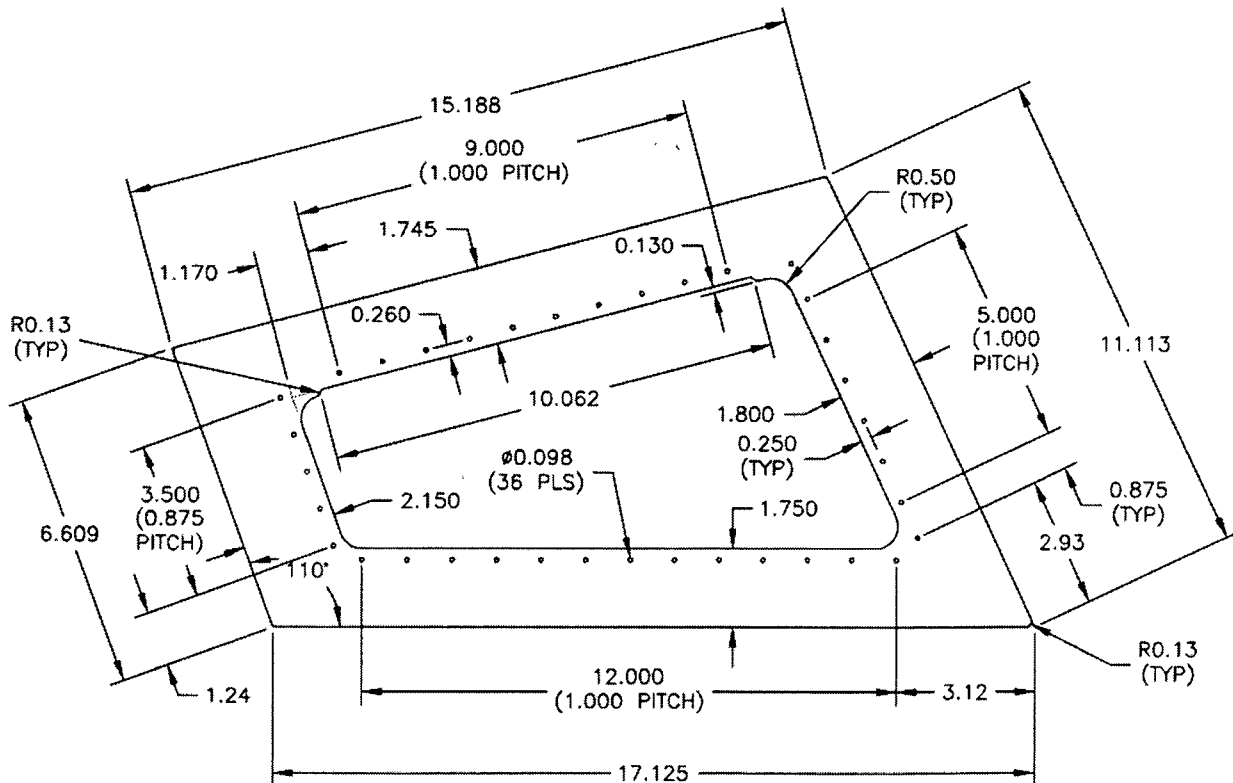
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN H	DRAWN BY H	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3259	REV. A SHEET 2 OF 6
DATE 04.02.25		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:4

RELEASED
04.04.05



D3259-1 PANEL

NOTES:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

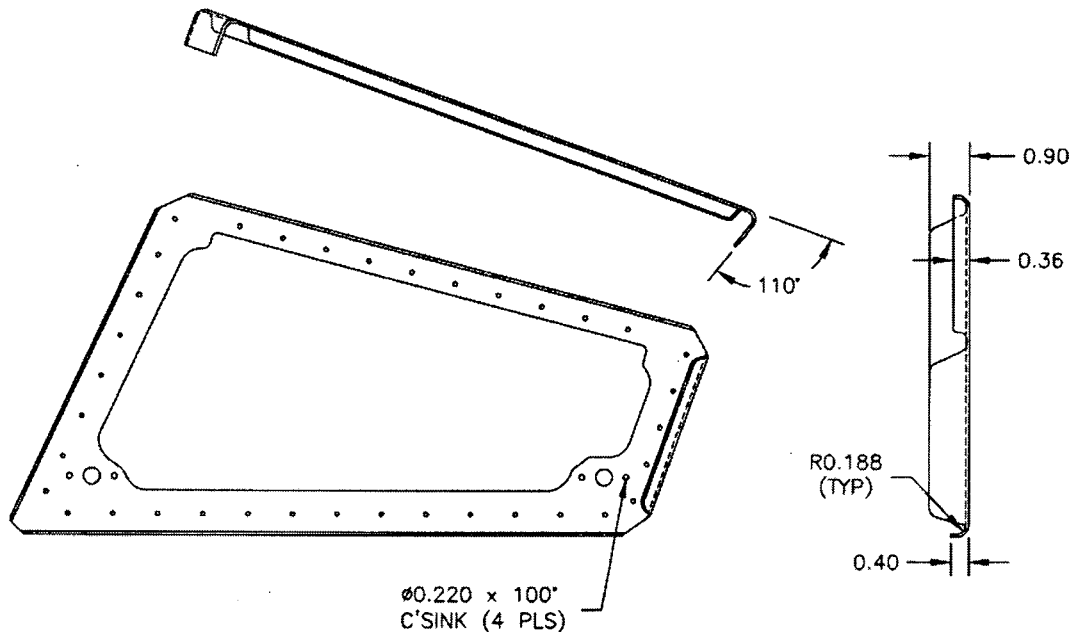
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN 17	DRAWN BY 17	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3259	REV. A SHEET 3 OF 6
DATE 04.02.25		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:4

RELEASED
04.04.14



D3259-3 DOUBLER BEND DETAIL (SHOWN)

BEND D3259-4 DOUBLER (OPPOSITE)

44302

D3259-3/-4 NOTES:

- 1) MANUFACTURE PER "D2359-A4.DWG"
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (M2024T3S.063)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

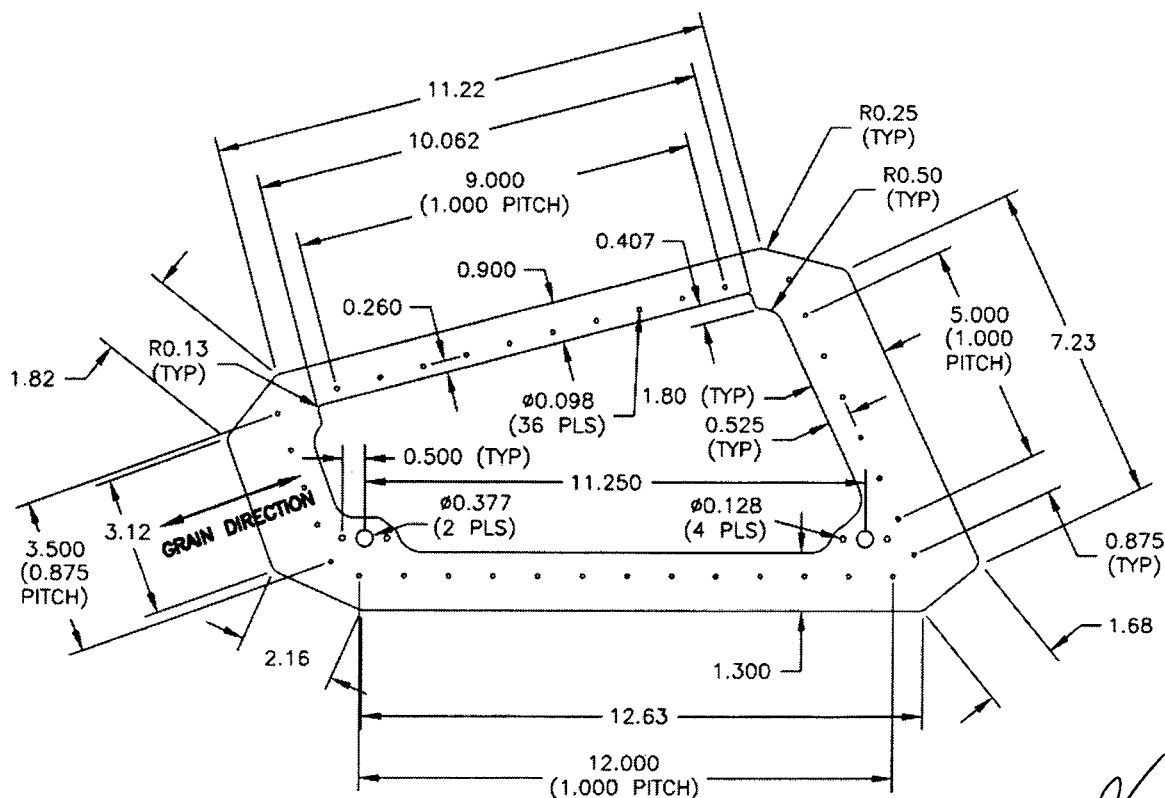
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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DATE 04.02.25		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:4

RELEASED
04.04.14 [Signature]



D3259-3/-4 DOUBLER FLAT PATTERN
($\phi 0.098$ HOLES TO COINCIDE WITH HOLES IN D3259-1)

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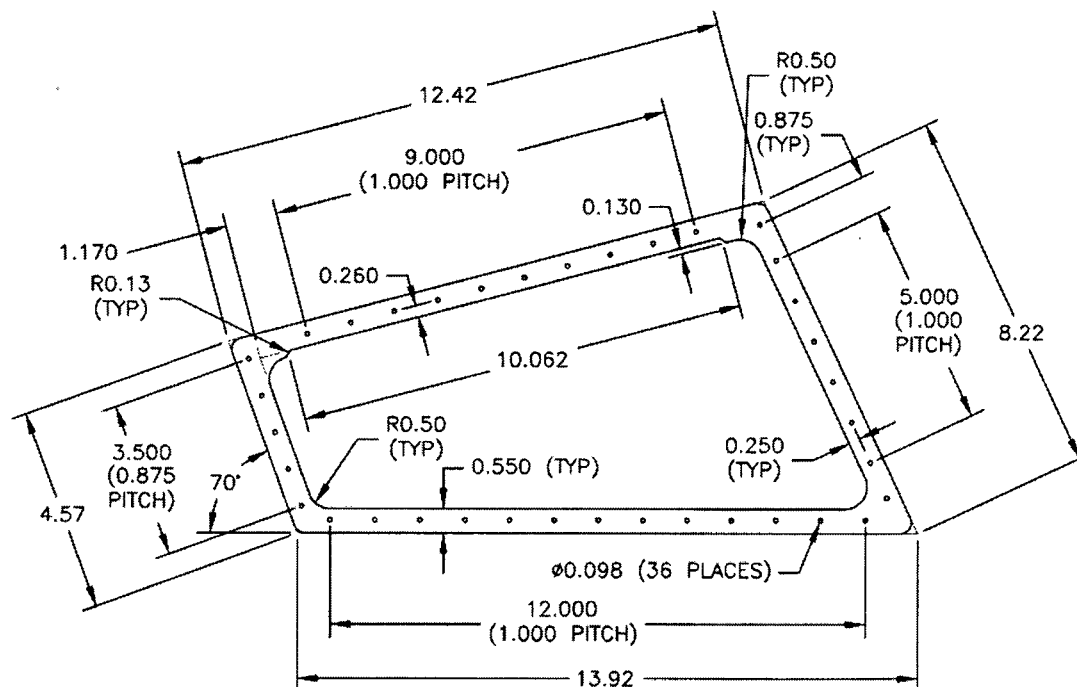
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



(Ø0.098 HOLES TO COINCIDE WITH HOLES IN D3259-1)

- 1) MANUFACTURE PER "D3259-A5.DWG"
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (M2024T3S.032)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

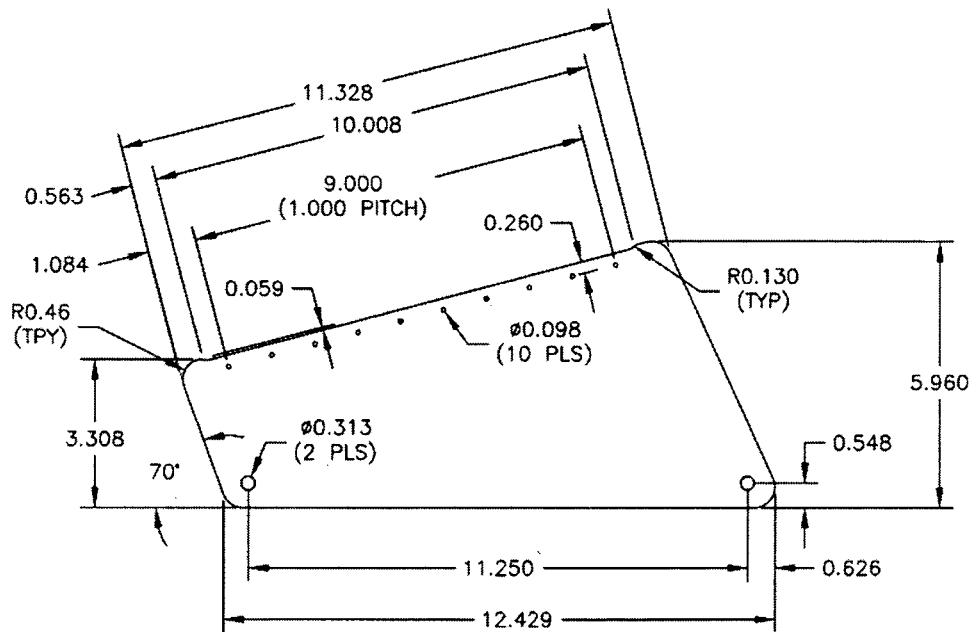
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN [Signature]	DRAWN BY [Signature]	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3259	REV. A SHEET 6 OF 6
DATE 04.02.25		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:4

RELEASED
04-04-14 [Signature]**D3259-7 DOOR**

44302

NOTES:

- 1) MANUFACTURE PER "D3259-A6.DWG"
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (M2024T3S.063)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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